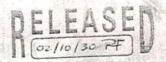
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SPLIT 19665 Work Order: DART AEROSPACE LTD D2890 Part Number: Description: Aft Crosstube Qty: Drawing: D2890 Rev. B; D6008 Rev. A Page 1 of 2

Step	Location	Procedure	Вул	Date	Qty
1	DC	Issue Traveller Dwg. not required RF 02.11.05	H	03.09.19	14
2	PG	Issue P/O: <u>Loo Skok</u> a) Extrude as per Dwg D6008 length = 180" (Ref. D6008-180) b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11)) Seamless aluminum tube c) Minimum ultimate tensile strength = 77ksi d) Minimum tensile yield strength = 66ksi e) Material certification required	u	03-09-22	14
3	RG	Receive and inspect for transit damage Ensure material certification attached	0	of 01-05	16
4	QC6	Inspect dimensions as per Dwg D6008 and check 180" length	13	01.01-13	16
5	FP *	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	1	04-01.13	16
6	LG	Bend as per Dwg D2890 and Folio FT002 Sign Page 2		2	
7	QC6	Inspect dimensions per Dwg D2890 Sign Page 2 See See 1			
8	LG	Deburr and Polish Sign Page 2			1 8
9	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube Sign Page 2	m	05 03 07	ŧ į
10	QC5	Inspect work to Step 9 Sign Page 2	2	05.05.07	1
11	ST	Identify and stock	CZ	05/03/07	+
12	AC	Cost / part: 926.40	Syc	05.05.10	1
13	DC	Close W/O 882.02	00	65.05.W	1

Rev	Date	Change	Revised By	Approved	
	THE RESERVE OF THE PARTY OF THE	New Issue, ECN 200	DM	The state of the s	
A			EC	CASE CONTRACTOR	
В		Remove painting step	LO 19F	\cap	
C	02.10.18	Re-format; Added spec	KJ KF	47	



DART AEROSPACE LTD	Work Order:	19665		
Description: Aft Crosstube	Part Number:	D2890		
Drawing: D2890 Rev. B; D6008 Rev. A	Qty:	14		
		Page 2 of 2		

W/O Step	Α	В	c	8	Е	F	G	н	I	J	К	L
6		0-1-11-B	DP 05-2-22	05-2-23								
7		Er alılı8	05.06.26	0503.02								
8		DP BE -		DP 05-3-7								
9		BD W		•								
10		5					3 4	-				

